

Work Order ID 80480

80480

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Item ID: D3542-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 21/02/2012 Start Qty: 800

8

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 800

8

Customer:

Reference:

Approvals: Process Plan: MCT

Date: 12/02/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3542	Rev A								

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 4.0" long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA684 Rev: AA & Dwg D3542 Rev: A 2-Deburr
per dwg D3443

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3542-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 21/02/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

SL 12/04/02

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

16 BL 12-4-2.

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

*****ENSURE TO MASK INSIDE BORE***** START TIME:
320°F OVEN TEMPERATURE: 8h45 FINISH
TIME: 9h15

m117338

16 & (AP) 12/04/03

W/O:		WORK ORDER CHANGES					
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Item ID: D3542-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 21/02/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 06/03/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				16	PL	12-4-3.	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <u>245</u> Memo	0.00 0.00				12/4/30		(160)	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MLJ		12/04/03	

12-04-13

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 80480

80480

Parent Item: D3542-1

D3542-1

Parent Item Name: Bracket

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev: A New Issue 07-04-23 JLM
IPP Rev: B updated powder coat per NCR 07.05.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B30000X01.5 00		Purchased	No			100	f	16.2710	0.3333333	2.666666			

M6061T6B30000X01 500

**

6061-T6 Bar 3.00 x 1.50

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT004	16.271	
109058	1.667	
114468	8.92	
117653	5.684	

M121192 X 5.6

OK 12/03/11

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Dart Aerospace Ltd

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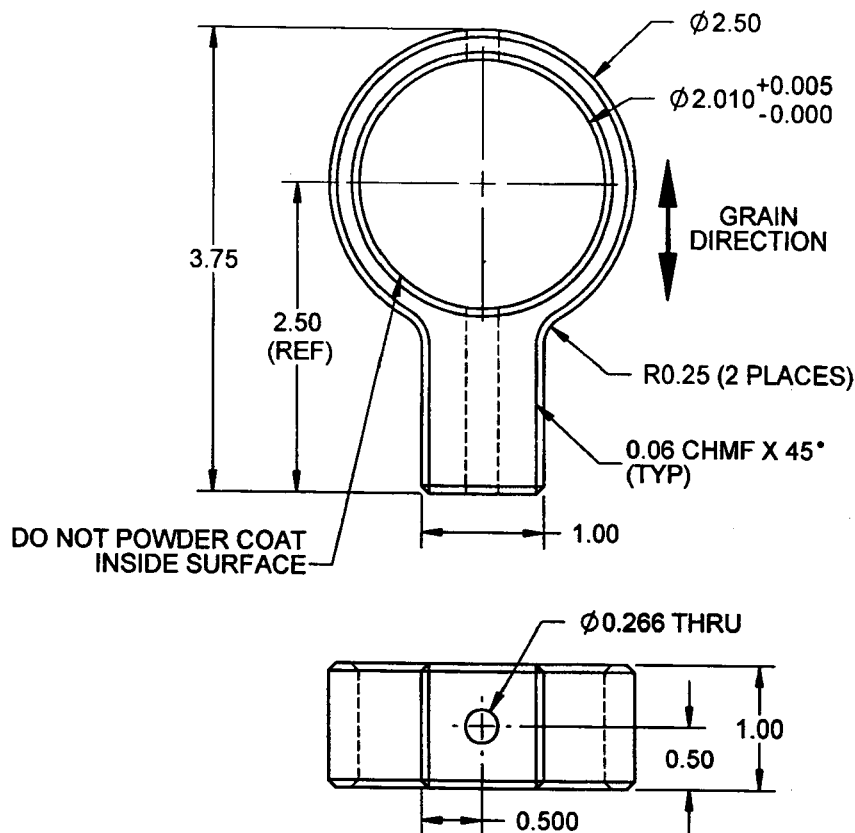
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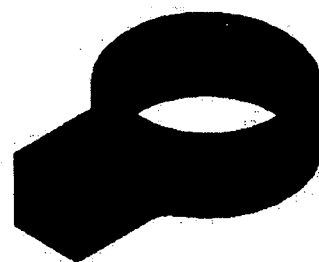
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3542	REV. A SHEET 1 OF 1
DATE 06.11.27	TITLE BRACKET		
REV A	DATE 06.11.27	DESCRIPTION NEW ISSUE	

RELEASED
070402



80480 M.L.J
12/02/24

D3542-1 BRACKET



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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